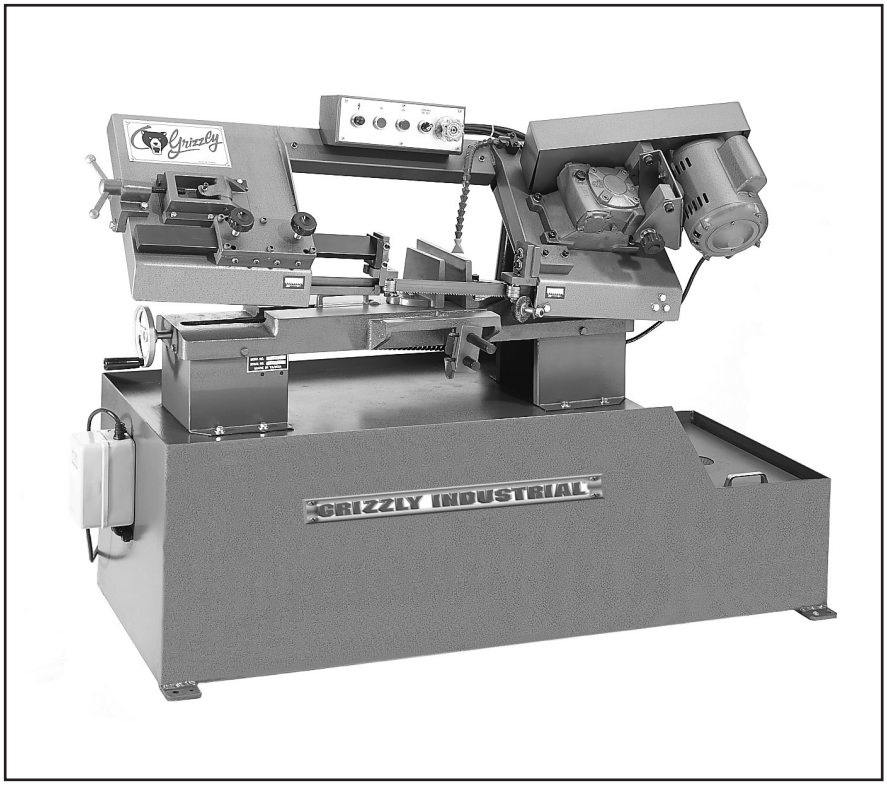
INDUSTRIAL, INC.

7" X 12" METAL-CUTTING BANDSAW

MODEL G1011Z

INSTRUCTION MANUAL



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SECTION 1: SAFETY

⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the equipment.**

⚠WARNING

Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES**. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on**.**
3. **KEEP WORK AREA CLEAN**. Cluttered areas and benches invite accidents.
4. **DON'T USE IN DANGEROUS ENVIRONMENT**. Don't use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY**. All children and visitors should be kept a safe distance from work area.
6. **MAKE WORK SHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DON'T FORCE TOOL**. It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.

⚠WARNING
Safety Instructions For Power Tools

9. **USE PROPER EXTENSION CORD**. Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

	LENGTH		
AMP RATING	**25ft**	**50ft**	**100ft**
0-6	18	16	16
7-10	18	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

10. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.

12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and frees both hands to operate tool.

13. **DON'T OVERREACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **DISCONNECT TOOLS** before servicing and changing accessories, such as blades, bits, cutters, and the like.

16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in.

17. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

18. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

19. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.

⚠WARNING

Additional Safety Instructions For The Metal-Cutting Bandsaw

1. Do not operate your bandsaw with dull or badly worn blades. Dull blades require more effort to use and are difficult to control. Inspect blades before each use.
2. Make sure the blade has been properly tensioned and is tracking on the center of the wheels
3. Always support stock in the vise and make certain it is firmly secured. Never attempt to hold material by hand while sawing.
4. Keep belt guard and bandsaw wheel covers in place when operating the machine.
5. Never force the saw through the cut. Allow the feed cylinder to control the rate of cutting. If the saw blade binds or stalls turn the power of immediately.
6. Never position fingers or thumbs in line with the cut. Serious injury could occur.
7. Periodically check the horizontal stop screw and the automatic shutoff limit switch to make sure they are properly adjusted.
8. Exercise great caution when replacing blades. Wear protective gloves and safety glasses when handling the blade
9. Support long or heavy workpieces which extend from the machine bed with a roller stand or other support device.
10. Habits – good and bad – are hard to break. Develop good habits in your shop and safety will become second-nature to you.

⚠WARNING

Operating this equipment has the potential to propel debris into the air which can cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).

⚠WARNING

Like all power tools, there is danger associated with the Model G1011 Bandsaw. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this tool with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠WARNING

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment or poor work results.

SECTION 2: CIRCUIT REQUIREMENTS

110V Operation

The Model G1011Z is wired for 110V, single phase operation only. The 1 HP motor will safely draw 16 amps at 110V. A complete Wiring Diagram for the motor and switches is provided near the back of this manual for more information.

Fusing

A 20-amp slow-blow fuse or circuit breaker should be used on the 110V circuit this bandsaw is connected to. Circuits rated any higher are not adequate to protect the motor from power surges. If you operate this bandsaw on any circuit that is already close to its capacity, it might blow a fuse or trip a circuit breaker. However, if an unusual load does not exist and a power failure still occurs, contact a qualified electrician or our service department.

Extension Cords

If you find it necessary to use an extension cord with the Model G1011Z, make sure the cord is rated Hard Service (grade S) or better. Refer to the chart in the standard safety instructions to determine the minimum gauge for the extension cord. The extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords when they become worn or damaged.

Grounding

In the event of an electrical short, grounding reduces the risk of electric shock by providing a path of least resistance to disperse electric current. This tool is equipped with a power cord having an equipment-grounding conductor. **See Figure 1.** The outlet must be properly installed and grounded in accordance with all local codes and ordinances.

⚠WARNING

This equipment must be grounded. Verify that any existing electrical outlet and circuit you intend to plug into is actually grounded. If it is not, it will be necessary to run a separate 12 A.W.G. copper grounding wire from the outlet to a known ground. Under no circumstances should the grounding pin from any three-pronged plug be removed. Serious injury may occur.

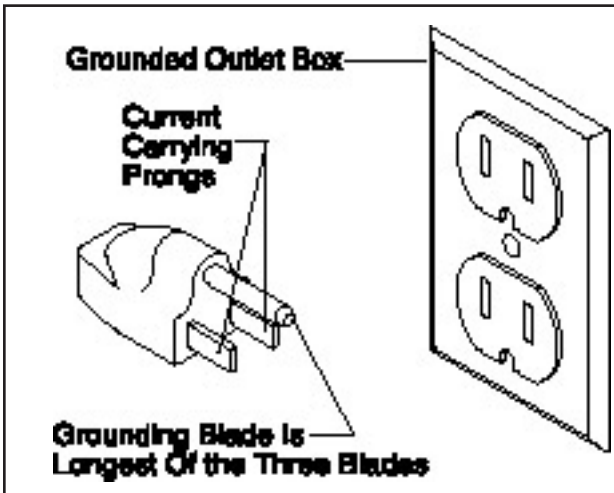


Figure 1. Grounded plug configuration.

SECTION 3: GENERAL INFORMATION

Commentary

Grizzly Industrial, Inc. is proud to offer the Model G1011Z 7" x 12" Metal-Cutting Bandsaw. This saw is a part of Grizzly's growing family of fine metalworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation, and proof of Grizzly's commitment to customer satisfaction.

The G1011Z features a fully adjustable down-feed, recirculating coolant pump, quick-release vise, centralized control panel and a 1 HP motor. The saw comes prewired and ready to operate at 110V.

We are also pleased to provide this manual with the G1011Z. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible. If you have any criticisms that you feel we should pay attention to in our next printing, please write to us at the address below:

Grizzly Industrial, Inc.
C/O Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

Most importantly, we stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
2406 Reach Road
Williamsport, PA 17701
Phone: (570) 326-3806
Fax: (800) 438-5901

E-Mail: techsupport@grizzlyindustrial.com
Web Site: http://www.grizzlyindustrial.com

The specifications, drawings, and photographs illustrated in this manual represent the Model G1011Z as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.

⚠CAUTION

To operate this or any power tool safely and efficiently, it is essential to become as familiar with it as possible. The time you invest before you begin to use your Model G1011Z will be time well spent. DO NOT operate this machine until you are completely familiar with the contents of this manual. Serious personal injury may occur.

Unpacking

The bandsaw is shipped from the factory in a carefully packed crate. If you find the machine to be damaged after you've signed for delivery and the truck and driver are already gone, you will need to file a freight claim with the carrier. Save the containers and all packing materials for inspection by the carrier or their agent. Without the packing materials, filing a freight claim can be difficult. If you need advice regarding this situation, please call us.

⚠WARNING

The G1011Z is a very heavy machine (626 lbs. shipping weight). DO NOT over-exert yourself while unpacking or moving your machine – get assistance. In the event that your machine must be moved up or down a flight of stairs, be sure that the stairs are capable of supporting the combined weight of people and the machine. Serious personal injury may occur.

NOTICE

Please keep all packaging materials until you are satisfied that the machine is in good condition. Should you need to file a freight claim, the carrier's agent will require inspection of those materials. Settling a claim can be difficult if packaging is not available.

When you are completely satisfied with the condition of your shipment, you should inventory its parts.

Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser. Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact. Always follow the usage instructions on the product you choose for clean up.

⚠CAUTION

Many of the solvents commonly used to clean machinery can be highly flammable, and toxic when inhaled or ingested. Always work in well-ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards. Keep children and animals safely away when cleaning and assembling this machine.

⚠WARNING

Do not use gasoline or other petroleum-based solvents to remove this protective coating. These products generally have low flash points which makes them extremely flammable. A risk of explosion and burning exists if these products are used. Serious personal injury may occur.

⚠CAUTION

All die-cut metal parts have a sharp edge (called "flashing") on them after they are formed. This is generally removed at the factory. Sometimes a bit of flashing might escape inspection, and the sharp edge may cause cuts or lacerations when handled. Please examine the edges of all die-cut metal parts and file or sand the edge to remove the flashing before handling.

Site Considerations

FLOOR LOAD

Your G1011Z Bandsaw represents a large weight load in a small footprint. Most commercial or residential shop floors should be sufficient to carry the weight of the machine. If you have any question about the floor structure being able to support the weight, contact your local city building inspector or a qualified civil engineer or contractor.

WORKING CLEARANCES

Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely run your machines in any foreseeable operation.

LIGHTING AND OUTLETS

Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle combined motor amp loads. Outlets should be located near each machine so power or extension cords are not obstructing high-traffic areas. Be sure to observe local electrical codes for proper installation of new lighting, outlets, or circuits.

⚠CAUTION

Make your shop "child safe". Ensure that your workplace is inaccessible to youngsters by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting or operating equipment.

Notes

SECTION 4: ADJUSTMENTS

Controls

The controls and major components for the G1011Z metal-cutting bandsaw are shown below in **Figure 2. Please use this drawing for reference when reviewing the following sections.**

A. Saw Bow.

B. Blade Guide Locking Knobs.

C. Control Panel - Contains On/Off buttons, Power-On indicator light, Coolant On/Off switch, and the Feed Rate valve.

D. Flexible Coolant Line.

E. Motor Mount (E1) and Belt Guard (E2).

F. Coolant Tank.

G. Gear Box.

H. Stationary Blade Guide.

I. Material Stop Assembly.

J. Moveable Blade Guide.

K. Vise Movable Jaw (K1) and Vise Lead Screw (K2).

L. Magnetic Starter Switch Box.

M. Blade Tensioning Adjustment Handle.

N. Blade Tracking Adjustment Setscrew.

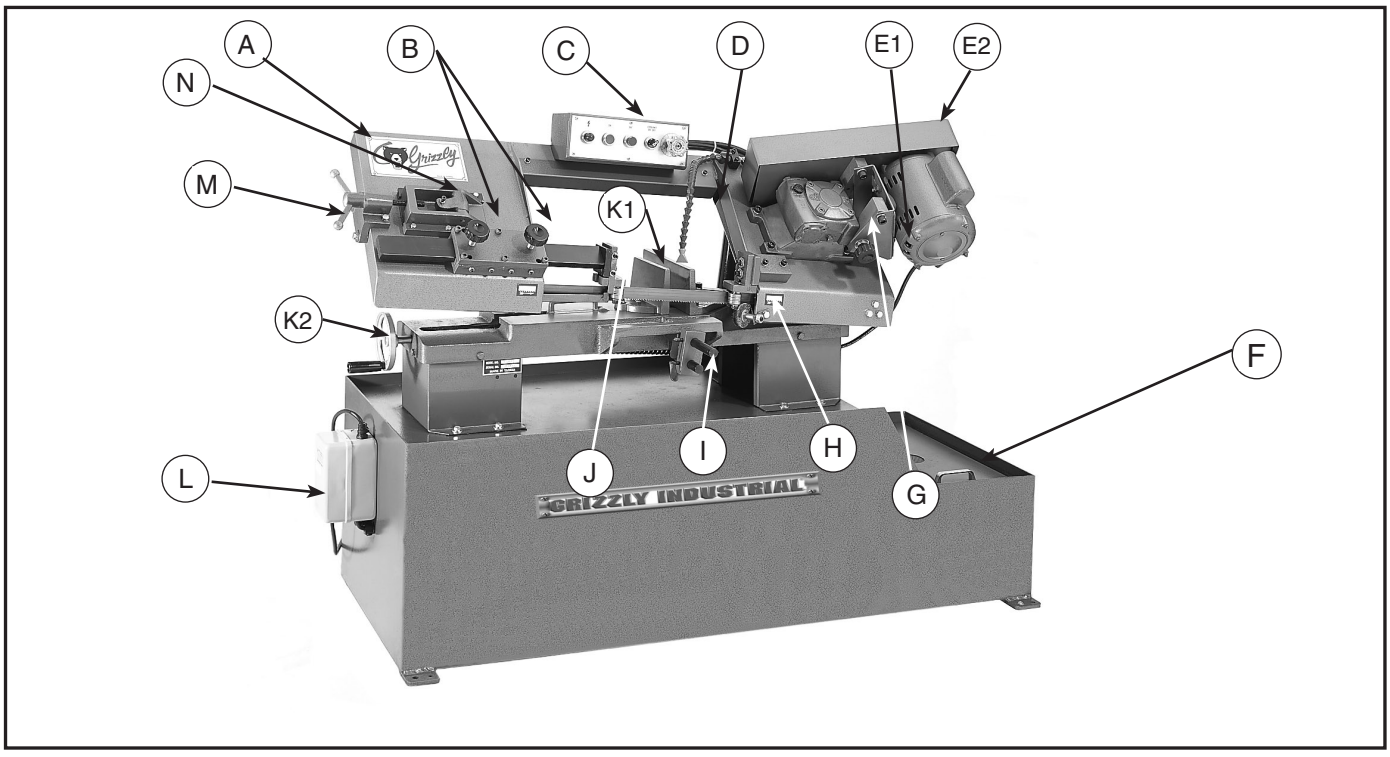


Figure 2. Controls and key components.

Saw Pressure

The pressure or force which the saw exerts when pushing through the workpiece is the result of the weight of the bow assembly counterbalanced by the amount of spring tension applied through the large coil spring on the back of the machine base. This should be set so there is a moderate amount of pressure. Harder or softer materials may require adjusting the head pressure for specific operations. See Adjusting Feed Rate in the Operations Section.

Spring adjustment is performed in the following sequence:

1. Raise saw bow to the open position, with the bow at the top of its travel.

2. Open the hydraulic feed rate valve all the way by turning it counterclockwise.

3. The saw bow should come down at a slow steady rate. You should be able to stop its travel with a light upward force from one or two fingers.

4. If it is hard to stop the travel, then the spring tension is too weak. Turn the adjusting nut on the spring's eye bolt (**See Figure 3)** counterclockwise so there is less of the eye bolt threads extending beyond the bracket.

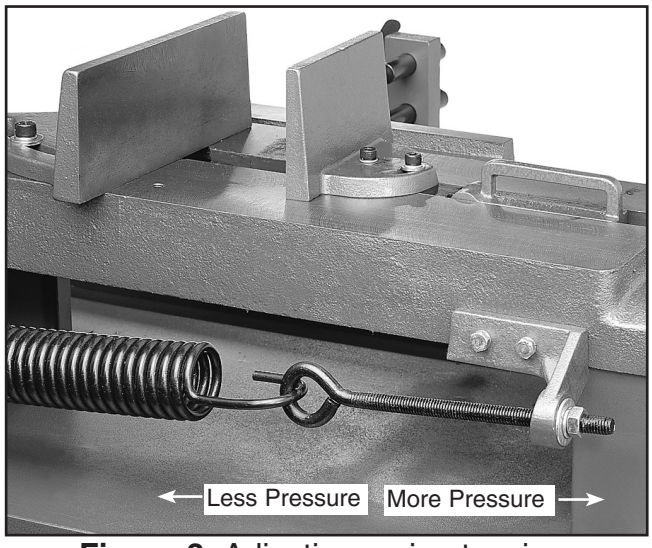


Figure 3. Adjusting spring tension.

5. If it is easy to stop the travel, or if the saw bow wants to reverse direction, then the spring tension is too strong. Turn the adjusting nut clockwise so more of the eye bolt threads extend beyond the bracket.

⚠WARNING

Use caution when adjusting the saw bow. Keep hands and arms clear of the cutting area when releasing the cylinder pressure to lower the saw. Even with the saw off, the weight of the bow can severely lacerate or break a hand or arm which might get trapped between the saw and the bed. Serious personal injury may result.

Tension/Tracking

Proper blade tension and tracking are important for optimum bandsaw performance. **See Figure 4** for bandsaw tension and tracking control locations.

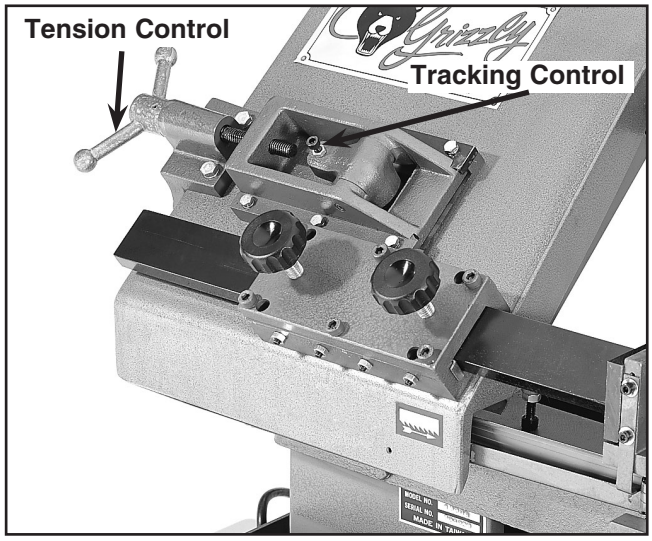


Figure 4. Tension and tracking controls.

TENSION

Since a number of blade metal types and tooth configurations will work in this saw, proper blade tension is dependent upon the type of blade and the material to be cut. Too much tension will result in blade breakage. A properly tensioned blade will track the cutting line accurately and the cut will be smoother.

Initially proper blade tension can best be achieved by determining the amount of blade deflection:

1. Ensure that the power is off and the saw is unplugged. Slide the blade guide assembly all the way to the left so the blade is fully exposed.

2. Press, with moderate pressure, on the face of the blade with your thumb.

3. Turn the tensioning knob at the top of the machine to change the amount of tension. The blade should flex no more than 1/4".

If the tension seems correct, make the other adjustments to the saw (aligning guides, tracking and speed) and test run it on a scrap piece of material. If the blade is not cutting properly, the tension may be incorrect and you'll need to readjust the tension. Remember to reduce the blade tension when the saw will not be in use, this will help to prevent premature wear or breakage of the blade.

TRACKING

To adjust tracking, disconnect the bandsaw from the power source. Raise the saw bow as high as possible and remove the cap screw from the hinged wheel cover. This will allow you to see the bandsaw wheel which has a machined step and a groove on it.

The socket head cap screw and lock nut on the top of the saw bow changes the plane of rotation of this wheel. Turn the wheel by hand (remove the belt guard and turn the motor pulley) for a few revolutions and observe whether the edge of the blade stays snug against the machined step. If it does not, adjust the cap screw until the blade stays against that step through several complete revolutions of the blade.

Once it stays centered when rotated by hand, lock the cap screw in place with the locking nut. Reconnect the machine to power and turn the machine on for just a few seconds. Observe the action of the blade and the wheel during this test, being sure to maintain a safe distance should the blade become disengaged. If the blade stays snug to the step, close the cover and secure with the cap screw.

⚠CAUTION

The saw blade is dangerously sharp. Use extra care when handling the blade, or working near it. Serious injury is possible.

Blade Guides

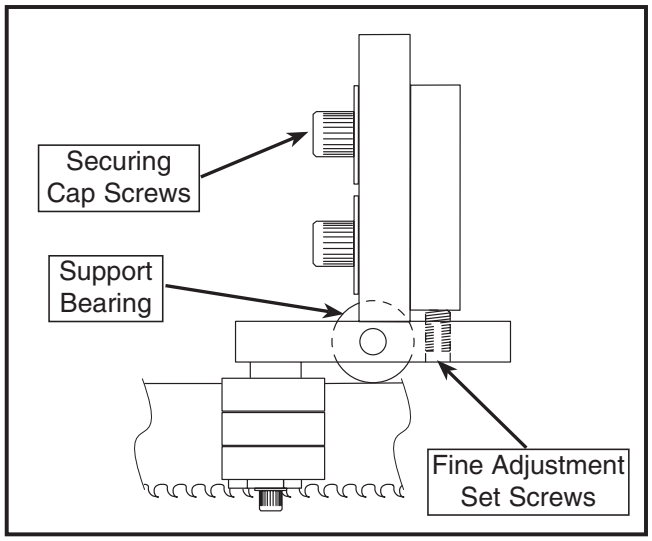


Figure 5. Support Bearing Adjustments.

Whenever changing a blade or adjusting tension and tracking, the left and right hand blade support bearings and guide bearings must be re-adjusted. Always adjust the guide bearings away from the blade before installing a new blade or making blade tracking adjustments. After blade tension and tracking are set correctly, re-adjust the left and right support bearings and guide bearings into position.

Adjustment of the guides is a three step procedure, consisting of adjustments to both the support bearings and guide bearings. The adjustments are as follows:

1. **Support Bearings -** The support bearings guide the back edge of the blade during the sawing operation. There is one bearing each on the left and right hand guides. **See Figure 5.** To adjust the support bearings, loosen the two cap screws until the blade guide block can be moved. Move the block so the bearing just touches the back of the blade. Tighten the cap screw closest to the blade, leave the other loose for now. Use the two fine adjustment set screws to back the bearing away from the blade until it is between .003" and .005" away from the edge of the blade. It may help to use a feeler gauge to check the gap. Be sure to adjust both the left and right hand sides.

2. **Guide Bearings -** The guide bearings ride on either side of the blade and ensure that the blade is not pushed too far laterally. To adjust the guide bearings, loosen the cap screw at the bottom of the bearing assembly. Use an open end wrench to move the brass hex nut which is an eccentric bushing. Turning the hex nut will move the bearing assembly into or away from the blade. When the bearings are just touching the blade, tighten the cap screw. Repeat this procedure for all four guide bearing assemblies. The bearings should be able to be rotated by hand while still touching the side of the blade. **See Figure 6**.

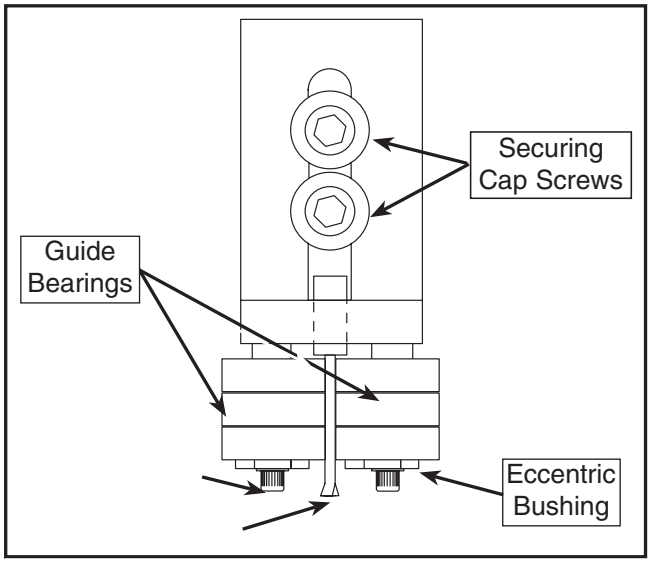


Figure 6. Guide Bearing Adjustments.

3. **Blade Square To Table -** The blade guide bearings must also be adjusted to make sure the blade is perpendicular to the surface of the table. Lower the saw bow all the way down until it contacts the stop screw. Use a machinist's square with one edge on the bed table surface and the other against the side of the blade. With the upper securing bolt still loose, rotate the guide bearings assembly block until the blade is square. Now tighten the upper and lower bolts to secure this position.

Horizontal Stop Screw

The horizontal stop screw limits the downward travel of the saw bow to keep the blade from running into the cast iron bed. The stop screw is located on the saw bow just next to the left hand blade wheel cover. **See Figure 7.**

Lower the saw bow by opening the feed rate valve. Stop the bow when the teeth are just ⅛" below the top surface of the bed. Adjust the stop screw so it touches the bed surface. Tighten the locknut on the stop screw.

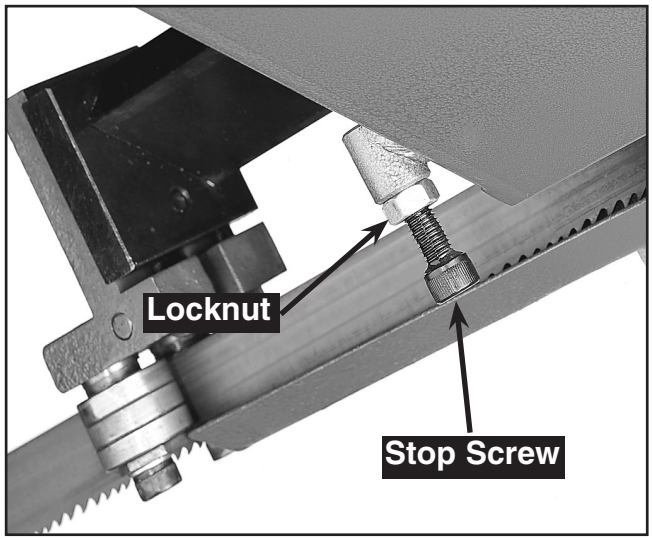


Figure 7. Horizontal stop screw.

Auto Shut-Off

The motor should shut off immediately after the blade has cut through the material and just before the head comes to rest on the horizontal stop screw. The automatic shut off limit switch is located near the saw bow pivot point next to the hydraulic cylinder. **See Figure 8.**

Turn the saw on **(after making sure the blade tensioning and tracking is correct)**, and lower the saw bow slowly. The saw should turn off just before the saw bow hits the stop screw. If it does not shut off at the proper point, the limit switch needs adjustment.

Loosen the two screws holding the limit switch bracket, and raise or lower the switch until the proper shut off point is achieved. If the switch is manually depressed, you will hear a click at the point the switch is being activated. You can use this activation point to set the switch in the proper position without the saw power being on.

After positioning the switch, double check its operation to make certain it is shutting off the blade just before contacting the horizontal stop screw.

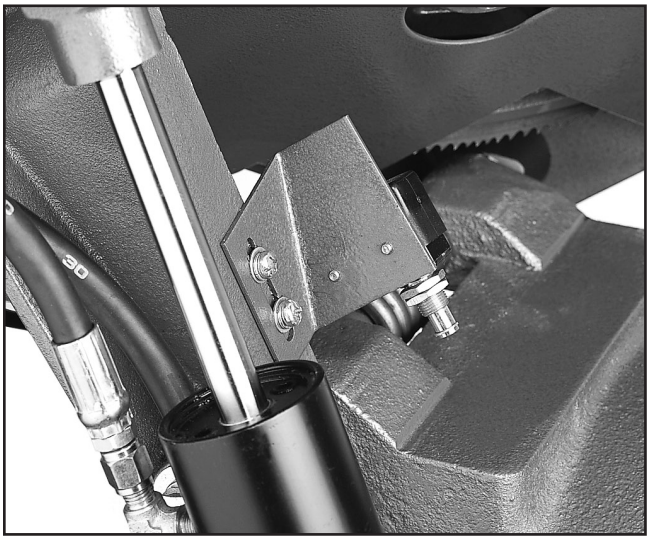


Figure 8. Automatic shut-off switch.

SECTION 5: OPERATIONS

The metal-cutting bandsaw is one of the most versatile machines in the shop. It can be used to cut off bar stock and structural steel to length as well as shaping metal into semifinished and finished components.

Pre-Run Check

There are many adjustment points and compensating differences to consider when operating this type of saw. Therefore, cutting results can be somewhat unpredictable if some or all of the crucial adjustments are neglected. Here are a few simple things you can do to increase the predictability of your bandsaw's performance:

1. **Blade Type -** Is the blade the proper tooth count and blade configuration for the material you need to cut? Is it sharp? Is it installed in the machine so the teeth are pointing in the right direction, according to the label on the saw bow.

2. **Blade Tensioning -** Is the blade tensioned properly? Is the blade tracking evenly on the wheels?

3. **Blade Guides -** Are the blade guides adjusted so the bearings are just touching the blade without binding. The movable blade guide on the left hand side should be moved as close to the material to be cut as possible.

4. **Speeds and Feeds -** Has the proper cutting speed been selected for the type of material to be cut? Has the proper feed rate for the bow been set for the type of material to be cut?

5. **Vise -** Is the material to be cut securely held in the vise? Is the vise oriented to the blade properly? Is the material situated in such a manner that the cutting will not begin on a sharp corner?

6. **Coolant -** Has the coolant reservoir been filled with the proper type of coolant solution to the manufacturer's mix ratio? Is the coolant nozzle directed at the cutting location and is the pump on?

7. **Operator Safety -** Is the machine operator wearing safety goggles and hearing protection? Avoid standing directly in front of the machine while it is cutting, stand to one side yet close enough to reach the control panel if needed.

WARNING

The Model G1011Z Bandsaw is a powerful, professional-quality machine, designed and built to provide outstanding results when used cautiously and with respect. Like any machine of its type, the Model G1011Z has some inherent dangers, which, when used with a lack of care, can result in serious injury or fatality. Please do not attempt to use this machine without familiarizing yourself with the instructions for assembly, adjustment, and safe operation. Failure to do so could result in serious personal injury, as well as property damage and damage to the machine.

Blade Selection

A bandsaw blade is a ribbon of steel subjected to tremendous strain. Be sure you use quality blades for the various types of cutting operations. The Grizzly G1011Z bandsaw accepts 1" x 101" blades. Bandsaw blades can be purchased welded, set, and sharpened ready-for-use from most saw shops. We also supply tool steel and variable pitch bi-metal blades for this saw. Please refer to our current catalog for prices and ordering information.

There are several key factors to consider in choosing a blade:

Tooth Pitch - The number of teeth per inch (TPI) on the blade, also known as tooth pitch. Select a pitch which will assure that at least three teeth are contacting the workpiece while cutting. This helps to distribute the cutting forces and avoids tooth breakage.

Tooth Form - There are four common forms of teeth on the blade: buttress, claw-tooth, precision and tungsten carbide. Precision is the most common and is the type supplied with this saw. **See Figure 9.** It is the most versatile and it provides a good surface finish.

Tooth Set - Set is the degree to which the teeth are bent away from the blade. Typical tooth set styles are raker, wave and straight set. Raker set is the most common with one tooth offset to the right, the next one to the left, and the third is straight. A wave set will have 3-4 teeth bent progressively one direction, then to the other in a wave-like pattern. A straight set is alternating teeth set right, then left.

Always select and use good-quality saw blades and choose the right blade for the job. Discuss your cutting requirements with your saw blade dealer to make sure you are getting the type of blade which best suits your need. Poor quality blades and improper use are often the cause of premature blade failure.

Many conditions can lead to breakage. Blade breakage is, in some cases, unavoidable, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable causes. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides. The most common causes of blade breakage are: (1) faulty alignment and adjustment of the guides; (2) Insufficient number of teeth contacting the cut; (3) feeding too fast; (4) tooth dullness or absence of sufficient set; (5) excessive tension; (6) using a blade with a lumpy or improperly finished weld; and (7), continuously running the bandsaw when not in use.

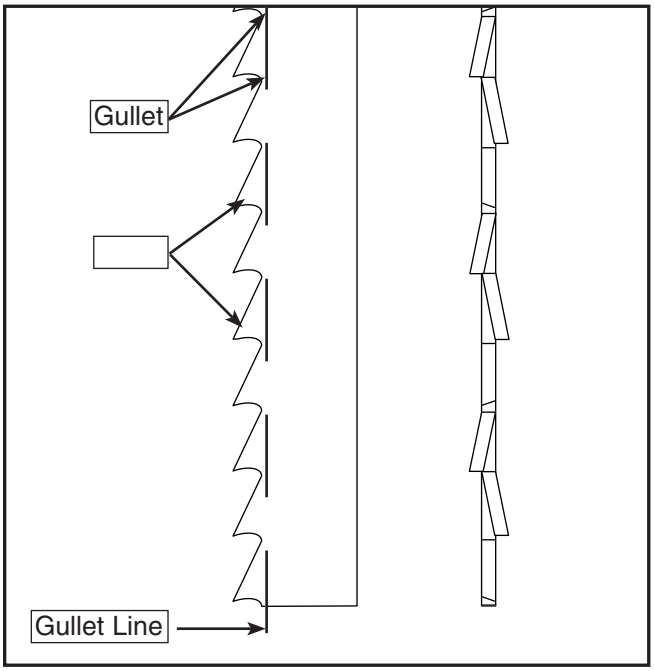


Figure 9. A precision tooth, raker set blade.

⚠WARNING

Operating this equipment has the potential to propel debris into the air which can cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).

Changing Blades

⚠WARNING

Use extreme caution when replacing blades. Teeth are dangerously sharp and coiled blades are prone to spring when released from their packaging. Use heavy leather or welding gloves and safety glasses or goggles whenever handling blades. Failure to do so could result in serious personal injury.

To remove the blade, ensure the power is disconnected and raise the saw bow as high as it will go:

1. Loosen tension on the blade by turning the tension knob. **See Figure 10**.

2. Open the gap between the blade bearing guides by loosening the locking screw and turning the eccentric bushing with an open end wrench. See Blade Guide Adjustment section.

3. Remove the cap screws from the cover plates over both of the bandsaw wheels. At the outer end of the bow the cover is hinged, at the other the plate must be completely removed.

4. Slide the blade off both wheels and out of the blade guides. ***Use caution, the blades are sharp!***

To replace the blade, ensure that the power is disconnected and:

1. Position the blade so the teeth are pointing down and toward the right when you are facing the front of the machine. There are blade tooth direction labels on the front of the saw. If the teeth will not point downward in any orientation, the blade is inside out. Twist it until it is right side out.

2. Slip the blade through the left and right hand guides and mount over the two wheels.

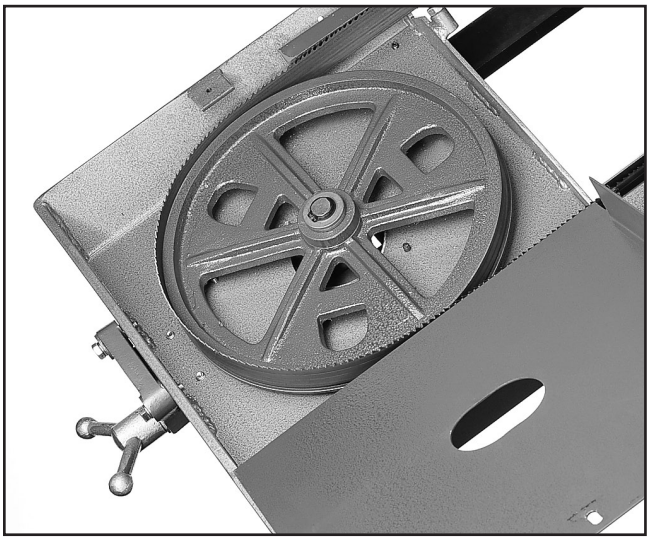


Figure 10. Outer wheel and cover.

3. Apply tension to the blade by turning the tension control knob. Refer to blade tensioning instructions earlier in this section.

4. Adjust the guide blocks and bearings as described in the previous section.

5. Close the wheel covers. Install the cap screws to secure the covers.

Cutting Speed

Blade speed selection should be made according to the material being cut. In general, the harder the material the slower the blade speed. The chart in **Figure 12** provides a general reference.

Material	Speed FPM	Pulley Used	
		Motor	Saw
Hard Materials - High Speed steels, stainless and heavy cross section mat'l	63	smallest	large
Moderately Hard - Tool, stainless and alloy steels, bearing bronzes	104	small	medium
Moderately Soft - Cast iron, mild steel, hard brass and bronze	156	medium	small
Soft Materials - Plastic, copper, soft brass, aluminum, other light materials	206	large	smallest

Figure 11. Cutting speeds and pulley selection.

The speed is changed by moving the V-belt onto the different sized pulleys on the motor and the saw. **See Figure 12.**

1. Remove the belt guard.
2. Loosen the motor tension knob.
3. Pull the motor over to relieve the belt tension. Move the belt to one of the four desired locations according to the speed chart. Never cross the belt so it is diagonal across the pulleys.
4. Tighten the motor tension knob.
5. Replace the belt guard.

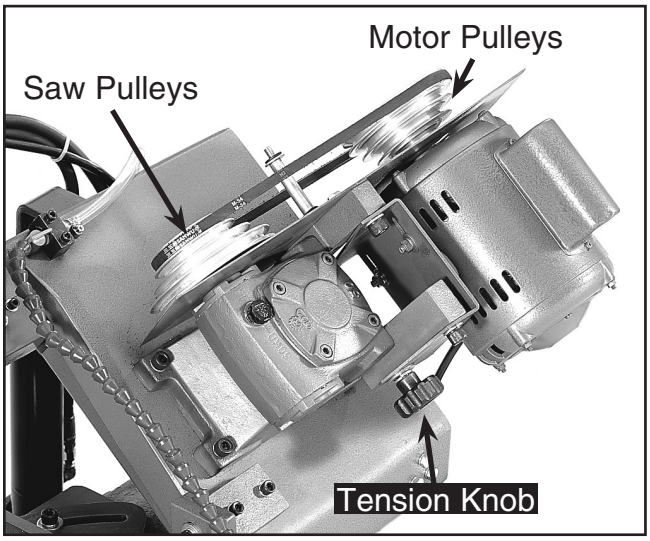


Figure 12. Motor and saw blade pulleys.

WARNING

DO NOT attempt to assemble, adjust, or maintain this machine while it is running. Turn off the switch, disconnect the bandsaw from its power source and wait for all moving parts to come to a complete stop before attempting any adjustments or maintenance. Failure to do so could result in serious injury.

Adjusting Feed Rate

The hydraulic cylinder connected to the saw bow regulates the rate at which the blade is lowered into the workpiece. Opening and closing the valve on the control panel **(See Figure 13)** controls the feed rate.

There is a by-pass valve on the side of the hydraulic cylinder which is preset at the factory. This by-pass allows the pressure to be relieved if for some reason the saw bow is forced downward. Do not attempt to adjust the by-pass valve setting.

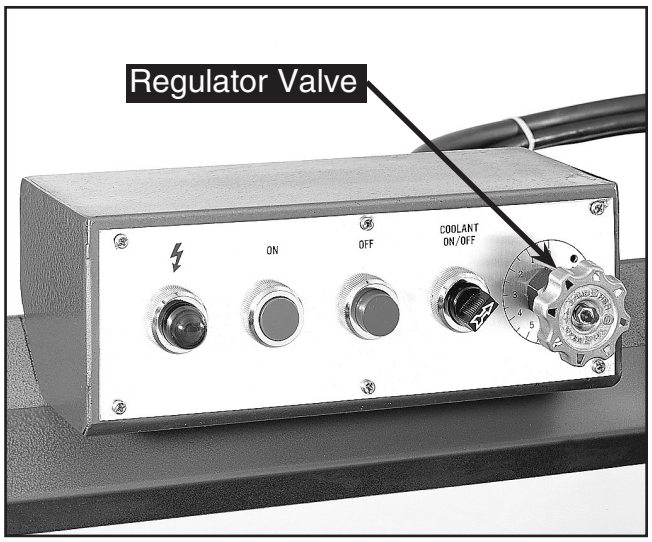


Figure 13. Feed regulator on control panel.

Coolant

Use of the coolant system is optional and is dependent upon the type of material being cut and the quantity. Directing coolant on the cut keeps the blade and workpiece from overheating, and it flushes the metal chips away from the tooth area to keep a good cutting surface.

The coolant tank is at the bottom of the machine on the right hand side. **See Figure 14.** Add the coolant solution to this tank, and locate the submersible pump so the suction intake is completely submerged. Generally water soluble fluids will work best. Refer to the specific mixing and replacement instructions of the coolant manufacturer. A drain plug is located at the corner of the tank to allow the easy draining of the coolant.

Turn the coolant pump on at the control panel, and direct the coolant nozzle directly at the cut.

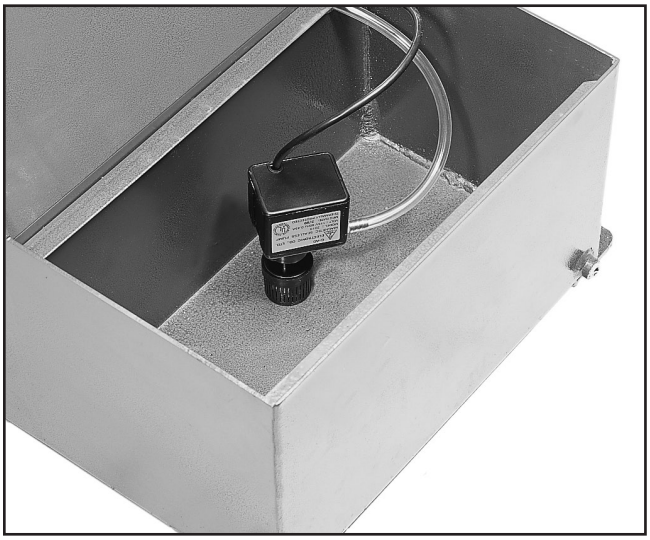


Figure 14. Coolant pump.

Guide Adjustment

The blade will cut best when the blade is supported as close to the workpiece as possible. Once the material has been secured in the vise, loosen the two knobs on top of the saw bow and slide the moveable guide over as close to the material as possible without interfering with the cut. Tighten the knobs. **See Figure 15.**

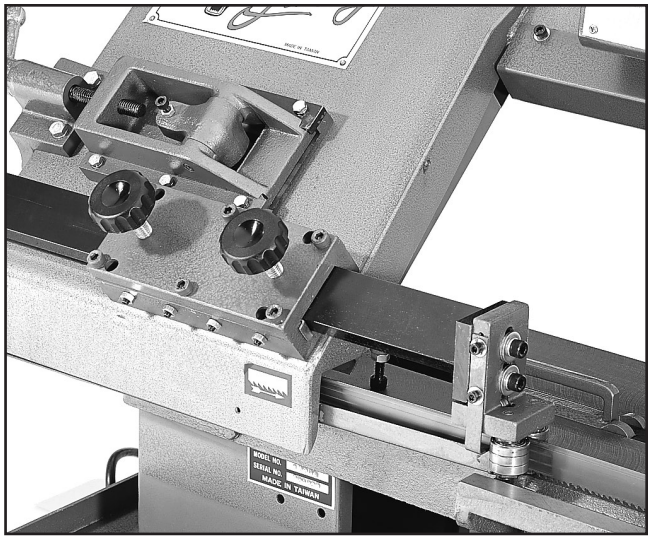


Figure 15. Moveable blade guide.

Vise and Stop

The workpiece(s) must always be secured in the vise for cutting. Never attempt to hold the material by hand, the cutting forces on a metal-cutting bandsaw are too strong. The angle of the cut can be revised by loosening the cap screws securing the vise jaws to the table and turning them to the angle desired. Tighten the cap screws.

One side of the vise slides along the bed when the handle lifts the threads off the lead screw. **See Figure 16.** Place the material to be cut between the sides of the vise jaws, and move the sliding portion as close to the material as possible. Seat the handle on the lead screw threads. Then using the handwheel on the left hand side of the bed, tighten the jaws until the material is firmly secured. Never release the vise by pulling up on the handle. Damage to the screw and nut will occur and may render it unusable.

Just in front of the vise, protruding from beneath the table, is the material stop bar. This can be set so that material can be cut to the same length over a series of cuts. Set the length of cut by measuring from the plane of the saw blade to the end of the stop bar. Tighten the thumb screws. Slide the material so it contacts the stop bar. Activate the saw and make the cut. Raise the saw bow and advance the material so it once again touches the stop bar. This will assure the cuts are made to the same exact length.

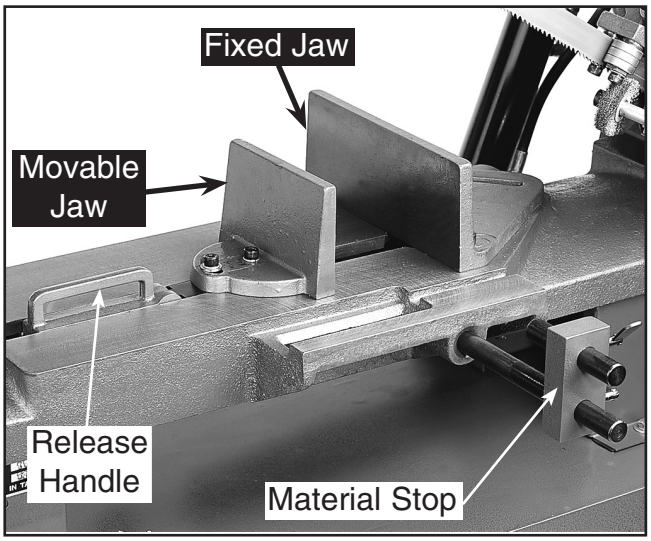


Figure 16. Vise components.

SECTION 6: MAINTENANCE

Table

The table and other non-painted surfaces on the Model G1011Z should be protected against rust and pitting. Wiping the saw clean after every use helps to ensure that coolant and chips won't begin to corrode the working surfaces of the bandsaw.

Protect the table surfaces with a light coating of oil periodically, especially when the saw will not be used for a time period.

V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and must be under the proper tension. The belt should be checked for cracks, fraying and wear. Belt integrity should be checked at least every 3 months; more often if the bandsaw is used daily.

Make sure the belt is tensioned properly whenever speed changes are made Refer to the Cutting Speed section for more complete detail on the speeds and moving the belt.

⚠CAUTION

Make your workshop "child-safe." Remove all safety keys from this and other machinery when they're not in use. Place sharp tools and blades high enough to discourage curious fingers. Store lubricants, finishes and other harmful chemicals where they can't be easily reached. Lock your workshop securely when you are away.

⚠WARNING

Operating this equipment has the potential to propel debris into the air which can cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).

Lubrication

The bearings used in the motor, the wheels and the blade guides are shielded and pre-lubricated ball bearings. These require no lubrication for the life of the bearings. All bearings are standard sizes and replacements can be purchased from our parts department or bearing supply store.

The rod on which the saw bow pivots needs an occasional shot of light oil to keep it moving smoothly.

The gear box should not need changing unless the oil becomes contaminated or leaks. To check the oil, lower the saw bow down all the way and wait a few minutes for the oil to drain down. Open the oil cap on top of the gearbox. The gear case is full when the oil is up to the bottom of the filler hole. Use 90W gear oil if it becomes necessary to change or add to the oil.

Coolant System

The coolant system must be properly filled with the proper mix of coolant and water in accordance with the coolant manufacturer's specifications. The coolant will need to be replaced periodically as the bandsaw is used more. Some coolant types also breakdown over time, or need additives to reduce the growth of bacteria or fungus in the solution.

There is a filter in the bottom of the coolant pump which will need periodic cleaning or replacement. Any time coolant flow does not seem sufficient, check the coolant sump for level, and check the pump filter.

Miscellaneous

Always be aware of the condition of your bandsaw before using it. Routinely check the condition of the following items and repair or replace as necessary.

1. Worn or damaged blade.
2. Worn switches.
3. Loose mounting bolts.
4. Worn or damaged support bearings or guide bearings.

SECTION 7: CLOSURE

The following pages contain general machine data, parts diagrams/lists, troubleshooting guide and Warranty/Return information for your Model G1011Z Metal-Cutting Bandsaw.

If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in Section 3 General Information The specifications, drawings, and photographs illustrated in this manual represent the Model G1011Z as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, add the new information to this manual and keep it for reference.

We have included some important safety measures that are essential to this machine's operation. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered as they apply to your specific situation.

⚠WARNING

Operating this equipment has the potential for flying debris to cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department listed in Section 3: General Information.

Additional information sources are necessary to realize the full potential of this machine. Trade journals, woodworking magazines, and your local library are good places to start.

⚠WARNING

The Model G1011Z was specifically designed for metal-cutting operations. **DO NOT MODIFY AND/OR USE THIS MACHINE FOR ANY OTHER PURPOSE. Modifications or improper use of this tool will void the warranty.** If you are confused about any aspect of this machine, **DO NOT** use it until you have answered all your questions. **Serious personal injury may occur.**

⚠WARNING

Like all power tools, there is danger associated with the Model G1011Z Metal-Cutting Bandsaw. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this tool with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

MACHINE DATA SHEET

Customer Service #: (570) 326-3806 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

GRIZZLY MODEL G1011 METAL-CUTTING BANDSAW

Design Type ..... Floor Model

Overall Dimensions:

Crate Size ..... 68" L x 27½" W x 47¼" H
Foot Print ..... 57" x 23"
Angle Cuts ..... 45° - 90°
Length ..... 63¼"
Width (front to back) ..... 27"
Height (head in high position) ..... 66½"
Height (from floor to cutting area) ..... 25½"
Weight (shipping) ..... 626 lbs.
Weight (Net) ..... 548 lbs.

Capacities:

Maximum Cutting Capacity ..... 7" Round Stock
Maximum Cutting Capacity ..... 7" x 11⅝" Rectangular
Bed Size ..... 8¼ x 17½" Angle
Cuts ..... 45° - 90°
Blade Size ..... 1" x 101"
Blade Speeds ..... 63, 106, 156, 206 FPM

Construction:

Main Body ..... Cast Iron
Stand ..... Formed and Welded
Wheels ..... Cast Iron
Gear Box ..... Sealed & Lubricated Worm Gear
Blade Guides ..... 7 Ball Bearing Guide

Motor:

Type ..... Capacitor Start Induction Run
Horsepower ..... 1 HP
Phase / Cycle ..... Single Phase / 60 HZ
Voltage ..... (prewired 110V) 110V/220V
Amps ..... 16 / 8
RPM ..... 1725 RPM
Bearings ..... Shielded and Lubricated-For-Life / Ball
Switch ..... Automatic Shut Off

Features:

..... Centralized Control Panel on Top of Saw Bow
..... Heavy-Duty, all steel one-piece base
..... Adjustable hydraulic down-feed—dial feed rate on the control panel
..... Worm-gear box has hardened & ground gears
..... Quick release vise for fast job changes
..... Built in coolant system (tank not removable) uses water soluble oil

Specifications, while deemed accurate, are not guaranteed.

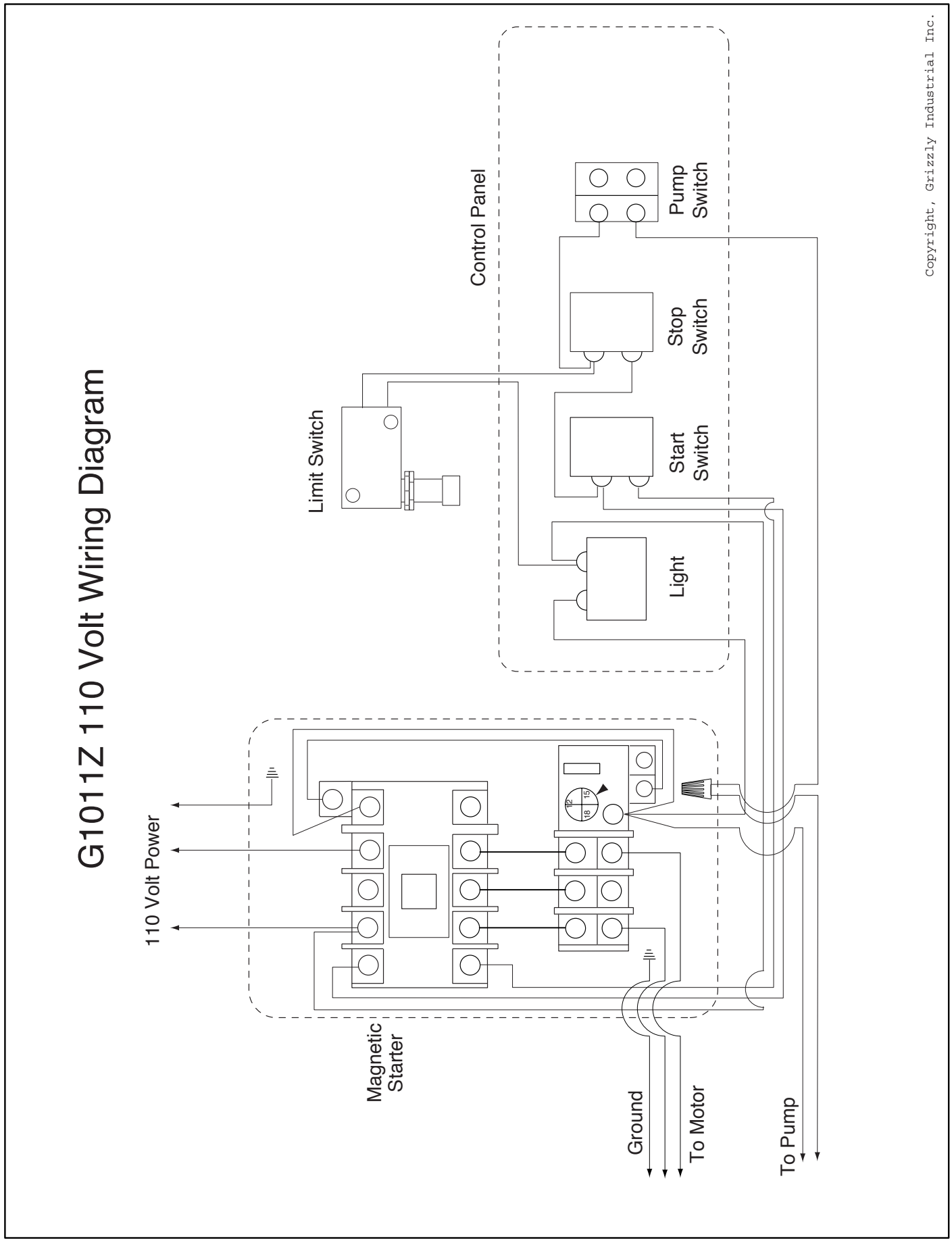
REVISED 5/99

TROUBLESHOOTING

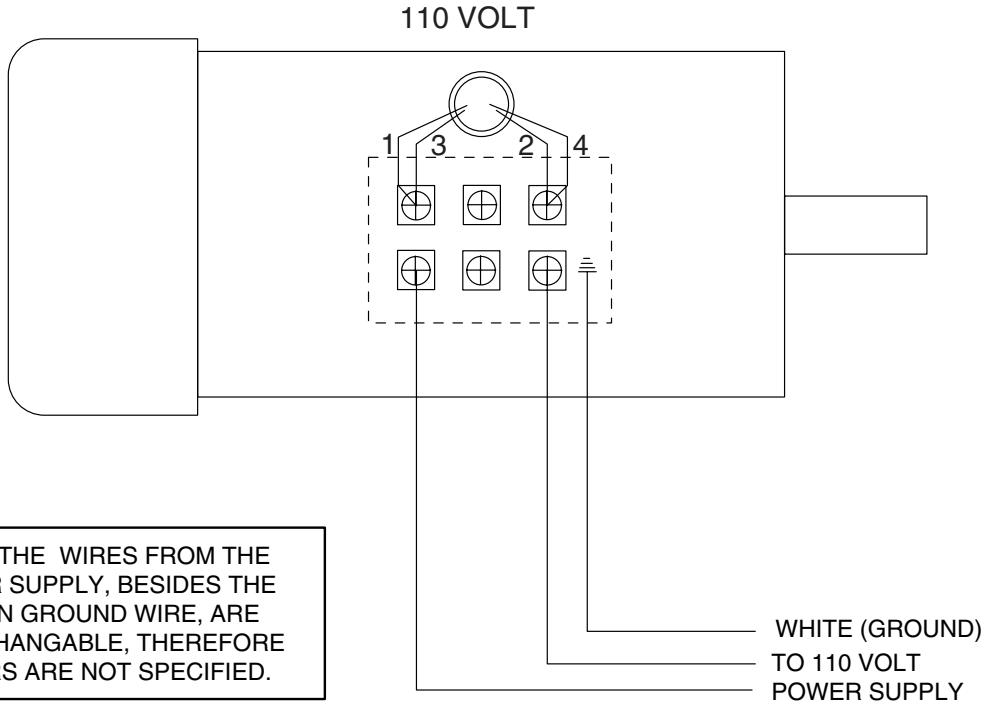
SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Teeth Breakage	1. Too few teeth per inch. 2. Excessive loading of gullets. 3. Excessive feed rate. 4. Work not secured in vise.	1. Use finer tooth blade (make sure at least three teeth-contact the workpiece). 2. Use coolant or increase coolant flow, or use coarser tooth blade. 3. Decrease feed rate. 4. Check that vise is tight to the bed and the movable jaw is tightened.
Blade breakage.	1. Teeth too coarse. 2. Misalignment of guides. 3. Dry cutting 4. Excessive speed. 5. Excessive feed 6. Excessive tension.	1. Use a finer tooth blade. 2. Adjust blade support and guide bearings. 3. Use coolant system. 4. Decrease cutting speed 5. Decrease cutting feed rate. 6. Reduce blade tension
Cut not straight.	1. Wheels out of line. 2. Guides out of line. 3. Excessive feed pressure. 4. Insufficient blade tension 5. Work not secured in vise.	1. Adjust blade tracking. 2. Adjust support and guide bearings. 3. Adjust spring tension to reduce feed pressure. 4. Increase blade tension. 5. Check that vise is tight to the bed and the movable jaw is tight on the material to be cut.
Blade Twisting.	1. Blade not aligned with blade guides. 2. Excessive feed pressure. 3. Excessive feed rate.	1. Adjust support and guide bearings, check alignment of blade to table. 2 Adjust spring tension to reduce feed pressure. 3. Reduce feed rate at control panel.
Premature tooth wear.	1. Dry cutting. 2. Blade too coarse. 3. Insufficient feed rate. 4. Excessive speed. 5. Tooth set is uneven.	1. Use coolant system. 2. Use finer tooth blade. 3. Increase feed rate so that blade does not ride in cut. 4. Reduce cutting speed. 5. Replace blade, or have it professionally sharpened.
Repetitive ticking noise when blade is on.	1. Blade weld contacting support or guide bearings. 2. Blade weld may be failing.	1. Use file or stone to smooth and round the back of the blade. 2. Inspect and replace blade if necessary.
Blade does not run evenly on wheels or runs off.	1. Tracking is not adjusted properly.	1. Adjust tracking.
Blade does not cut evenly.	1. Blade tension is incorrect. 2. Tooth set is uneven. 3. Teeth are sharper on one side than the other.	1. Adjust tension. 2. Replace blade, or have it professionally sharpened. 3. Replace blade, or have it professionally sharpened.
Blade contacting table surface.	1. Horizontal stop screw not adjusted.	1. Adjust horizontal stop screw.
Blade does not stop after cut is complete.	1. Automatic shut-off switch not adjusted.	1. Adjust automatic shut-off switch.

TROUBLESHOOTING

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Motor will not start.	1. Low voltage. 2. Open circuit in motor, control panel or magnetic starter.	1. Check power line for proper voltage. 2. Inspect all lead connections on motor, switch and starter for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	1. Short circuit in line cord or plug. 2. Short circuit in motor or loose connections. 3. Incorrect fuses or circuit breakers in power line.	1. Inspect cord or plug for damaged insulation and shorted wires. 2. Inspect all connections on motor for loose or shorted terminals or worn insulation. 3. Install correct fuses or circuit breakers.
Motor overheats.	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.	1. Inspect connections on motor for loose or shorted terminals or worn insulation. 2 Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Motor and blade speed slows when operating.	1. Excessive feed pressure. 2. Blade is dull.	1. Adjust spring tension to reduce feed pressure.- 2. Replace blade.


G1011Z 110 Volt Wiring Diagram
Control Panel
Pump Switch
Stop Switch
Start Switch
Light
Limit Switch
110 Volt Power
Magnetic Starter
Ground
To Motor
To Pump
Copyright, Grizzly Industrial Inc.

G1011Z WIRE DIAGRAM



NOTE: THE WIRES FROM THE POWER SUPPLY, BESIDES THE GREEN GROUND WIRE, ARE INTERCHANGABLE, THEREFORE COLORS ARE NOT SPECIFIED.

PARTS LIST

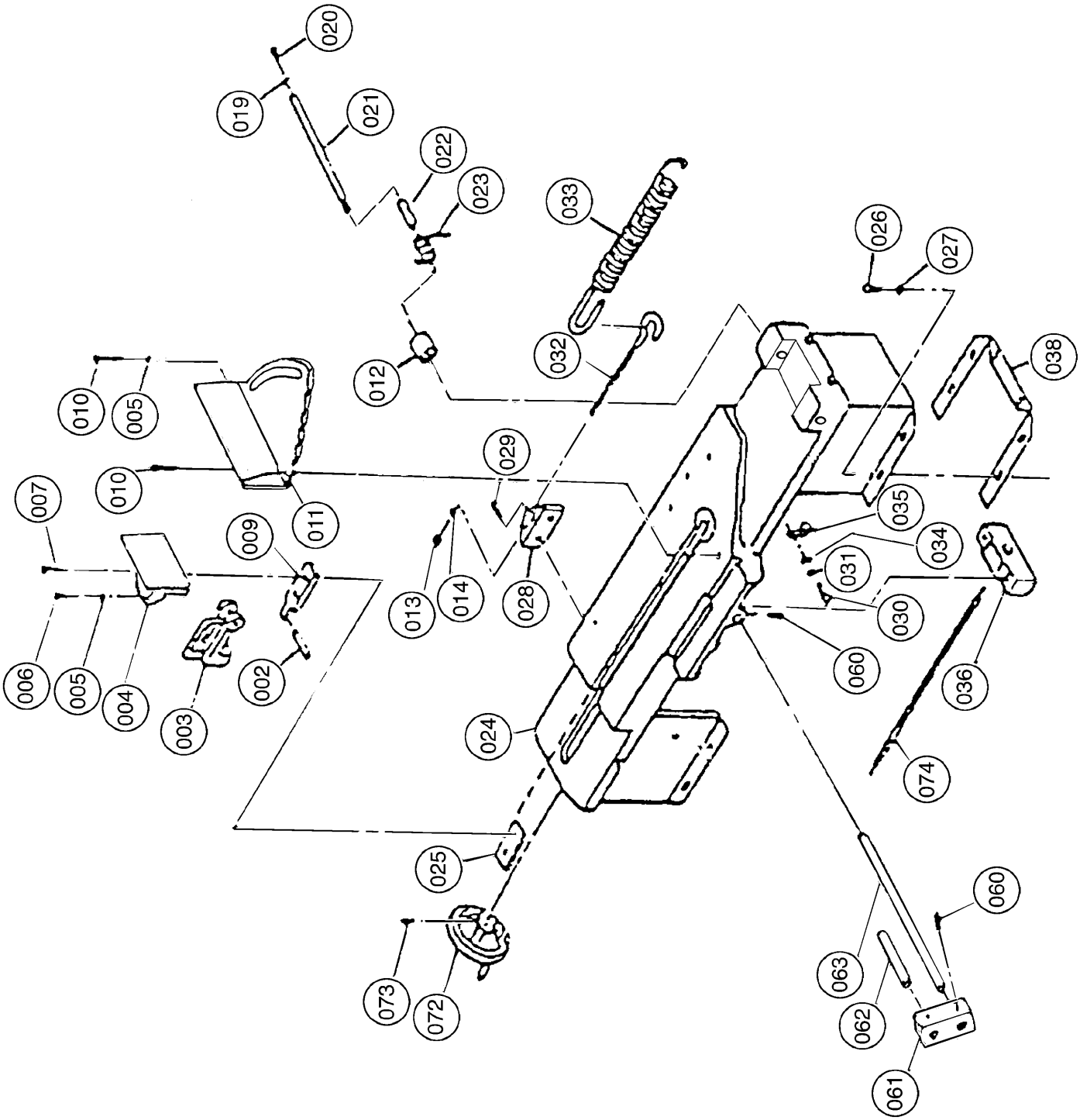
REF	PART #	DESCRIPTION
002	P1011Z002	DOWEL PIN
003	P1011Z003	RAPID NUT
004	P1011Z004	MOVABLE JAW
005	PW01M	WASHER 8mm
006	PSB45M	CAP SCR M8-1.25 x 45mm
007	PSB45M	CAO SCR M8-1.25 x 45mm
009	P1011Z009	MOVABLE JAW SUBPLATE
010	PSB44M	CAP SCR M10-1.5 x 28mm
011	P1011Z011	FIXED JAW
012	P1011Z012	PIVOT SHAFT NUT
013	P1011Z013	NUT
014	PW01	FLAT WASHER ½"
019	PW01M	FLAT WASHER 8mm
020	PB03M	HEX BOLT M8-1.25 x 16mm
021	P1011Z021	PIVOT SHAFT
022	P1011Z022	SLEEVE
023	P1011Z023	TORSION SPRING
024	P1011Z024	TABLE
025	P1011Z025	RETAINING PLATE
026	PB07M	HEX BOLT M8-1.25 x 25mm
027	PW01M	FLAT WASHER 8mm
028	P1011Z028	FEED SUPPORT BRACKET
029	PB07M	HEX BOLT M8-1.25 x 25mm
030	PSB13M	CAP SCR M8-1.25 x 30
031	PLW04M	LOCK WASHER 8mm
032	P1011Z032	EYE BOLT
033	P1011Z033	FEED SPRING
034	PW01M	FLAT WASHER 8mm
035	P1011Z035	HOSE CLAMP
036	P1011Z036	SPINDLE BRACKET
038	P1011Z038	GASKET
060	P1011Z060	SETSCREW
061	P1011Z061	WORK STOP ARM
062	P1011Z062	UPPER WORK STOP ROD
063	P1011Z063	LOWER WORK STOP ROD
072	P1011Z072	HAND WHEEL
073	P1011Z073	SETSCREW
074	P1011Z074	CLAMP SPINDLE
079	P1011Z079	PUMP
102	PSB540M	CAP SCR M5-.8 x 10mm
103	P1011Z103	BLADE GUARD

REF	PART #	DESCRIPTION
113	P1011Z113	SAW BOW
114	P1011Z114	TILT ARM
117	P1011Z117	PIN
118	P1011Z118	RETAINING RING
119	P1011Z119	CYLINDER PIVOT BRKT
122	P1011Z122	HYDRAULIC CYLINDER
126	P1011Z126	DRIVE WHEEL COVER
130	P1011Z130	BRACKET
132	P1011Z132	BRUSH SPACER
133	P1011Z133	CHIP BRUSH
134	P1011Z134	SHOULDER SCREW
136	P1011Z136	IDLER WHEEL COVER
144	P1011Z144	COLUMN BLADE COVER
145	P1011Z145	NOZZLE
146	PSB07M	CAP SCR M6-1 x 30mm
147	P1011Z147	COOLANT MOUNT
148	P1011Z148	BARB FITTING
150	P1011Z150	HOSE
151	P1011Z151	BLADE
201	PRP03M	ROLL PIN M5 x 20mm
202	P1011Z202	HANDLE
203	P1011Z203	THREADED ROD
204	PB07M	HEX BOLT M8-1.25 x 25mm
205	P1011Z205	TENSION BLOCK
207	P1011Z207	ROLL PIN
208	PN01M	HEX NUT M6-1
209	PSB30M	CAP SCREW M6-1 x 45mm
210	P1011Z210	YOKE AND SHAFT ASSY
211	P1011Z211	SLIDE
213	P1011Z213	THRUST BEARING
214	P1011Z214	IDLER WHEEL
215	P1011Z215	BRONZE BEARING
217	P1011Z217	RETAINING RING
218	P1011Z218	SLIDE PLATE
219	PSB01M	CAP SCREW M6-1 x 16mm
220	PB26M	HEX BOLT M8-1.25 x 30mm
221	PB18M	HEX BOLT M6-1 x 15mm
222	P1011Z222	GIB
223	PSB07M	CAP SCREW M6-1 x 30mm

REF	PART #	DESCRIPTION
224	PW03M	FLAT WASHER
301	P1011Z301	KNOB
302	P1011Z302	GUIDE BAR COVER
303	PSB31M	CAP SCR M8-1.25 x 25mm
304	P1011Z304	SETSCREW
305	P1011Z305	GUIDE BAR
308	P1011Z308	DOWEL PIN
309	P1011Z309	BLADE GUIDE BRACKET
310	P1011Z310	STRAIGHT BUSHING
312	P1011Z312	ECCENTRIC BUSHING
313	PSB13M	CAP SCR M8-1.25 x 30mm
314	PW01M	FLAT WASHER 8mm
316	P1011Z316	BLADE GUIDE SUBPLATE
318	P1011Z318	GUIDE BAR CRADLE
319	PSS12M	SETSCREW M6-1 x 25mm
320	PN01M	HEX NUT M6-1
321	P1011Z321	GIB
401	P1011Z401	BACK PANEL
402	P1011Z402	DRIVE PULLEY
403	PVM34	V-BELT M34 3L340
404	P1011Z404	BELT GUARD
405	P1011Z405	STUD
406	PW01M	FLAT WASHER 8mm
407	P1011Z407	KNOB-PULLEY COVER
408	P1011Z408	MOTOR PULLEY
409A	P1011Z409A	MOTOR MOUNT
409B	P1011Z409B	MOTOR MOUNT
410	P1011Z410	MOTOR MOUNT PLATE
411	P1011Z411	MOTOR 1 HP
412	PLW05M	LOCK WASHER 12mm
413	PSB36M	CAP SCR M12-1.75 x 25mm
414	P1011Z414	DRIVE WHEEL
415	P1011Z415	SPEED REDUCER
416	PSB47M	CAP SCR M10-1.5 x 30mm
417	PSS05M	SETSCREW M5-.8 x 10mm
418	PB31M	HEX BOLT M10-1.5 x 40mm
420	PB03M	HEX BOLT M8-1.25 x 16mm
421	PLW04M	LOCK WASHER 8mm

REF	PART #	DESCRIPTION
422	PW01M	FLAT WASHER 8mm
423	P1011Z423	KNOB-MTR ADJUST PLATE
424	PW01	FLAT WASHER ½"
428	PB03M	M8-1.25 x 16mm
429	PLW04M	LOCK WASHER 8mm
430	PW01M	FLAT WASHER 8mm
501	PSB13M	CAP SCR M8-1.25 x 30mm
502	PW01M	FLAT WASHER 8mm
503	P1011Z503	BLADE GUIDE BRACKET
506	PSB12M	CAP SCR M8-1.25 x 40mm
507	P1011Z507	GUIDE BAR
509	P1011Z509	DOWEL PIN
510	PSS24M	SETSCREW M5-.8 x 20mm
511	P1011Z511	JAM NUT
512	P1011Z512	ECCENTRIC BUSHING
513	P1011Z513	BEARING
514	P1011Z514	STRAIGHT BUSHING
515	P1011Z515	SOC HD CAP SCREW
516	P1011Z516	BEARING
517	P1011Z517	SPACER
601	P1011Z601	FLOW CONTROL VALVE
602	P1011Z602	90 DEG CONNECTOR
603	P1011Z603	STRAIGHT CONNECTOR
604	P1011Z604	HYDRAULIC HOSE
605	P1011Z605	HYDRAULIC CYLINDER
606	P1011Z606	CLEVIS
607	P1011Z607	LOCKNUT
608	P1011Z608	PIN
609	P1011Z609	SNAP RING
610	P1011Z610	SNAP RING
611	P1011Z611	SHAFT

MAIN BODY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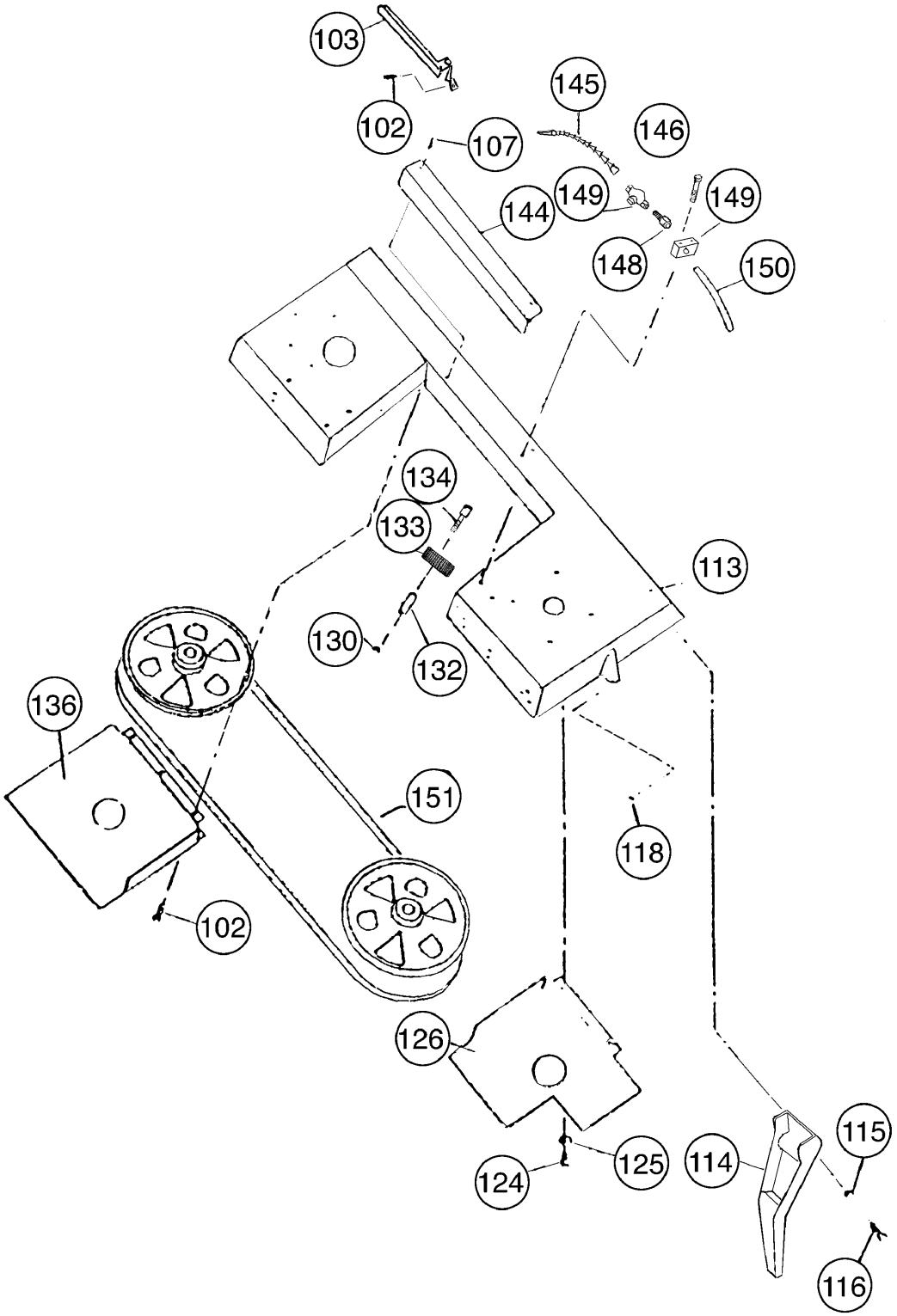
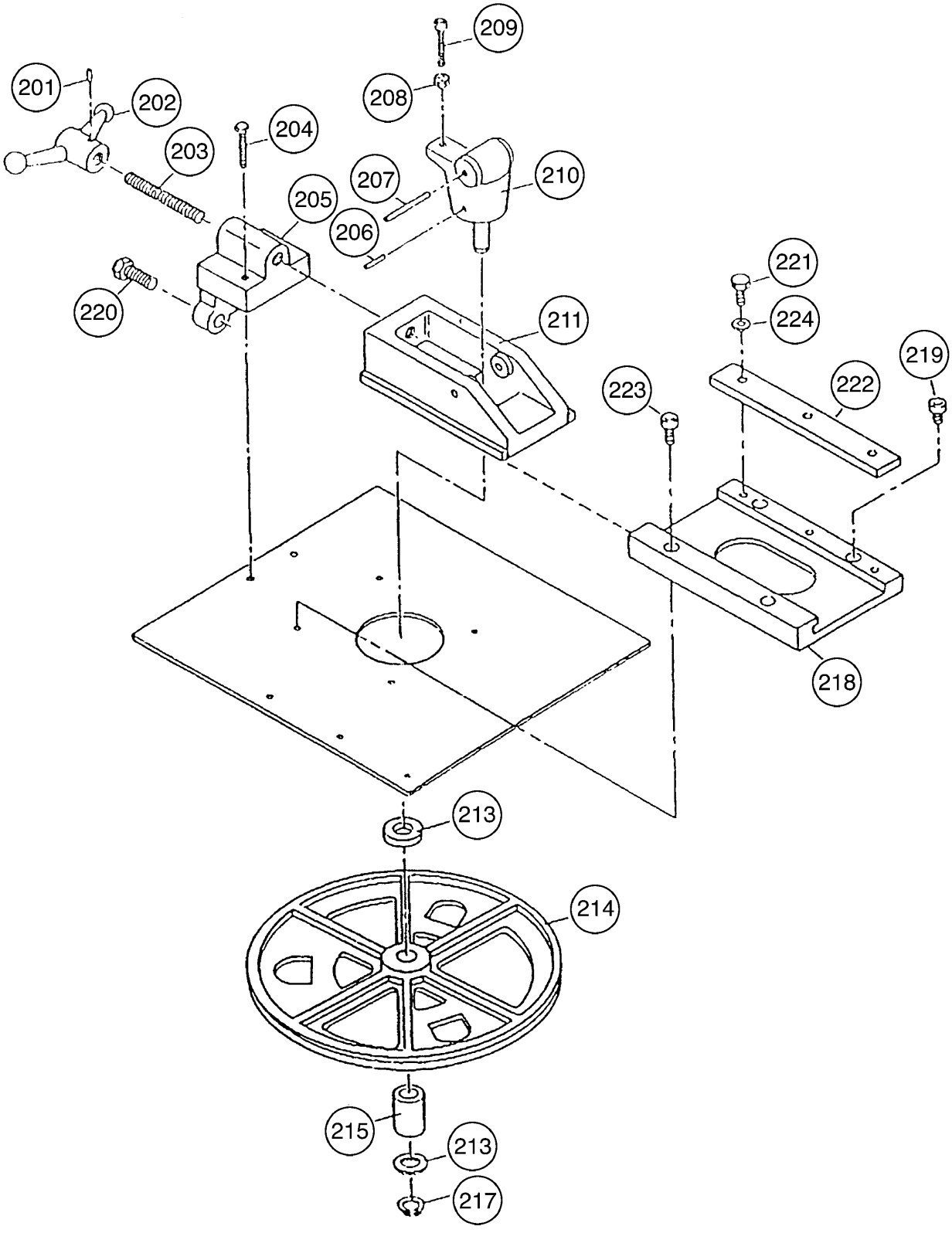
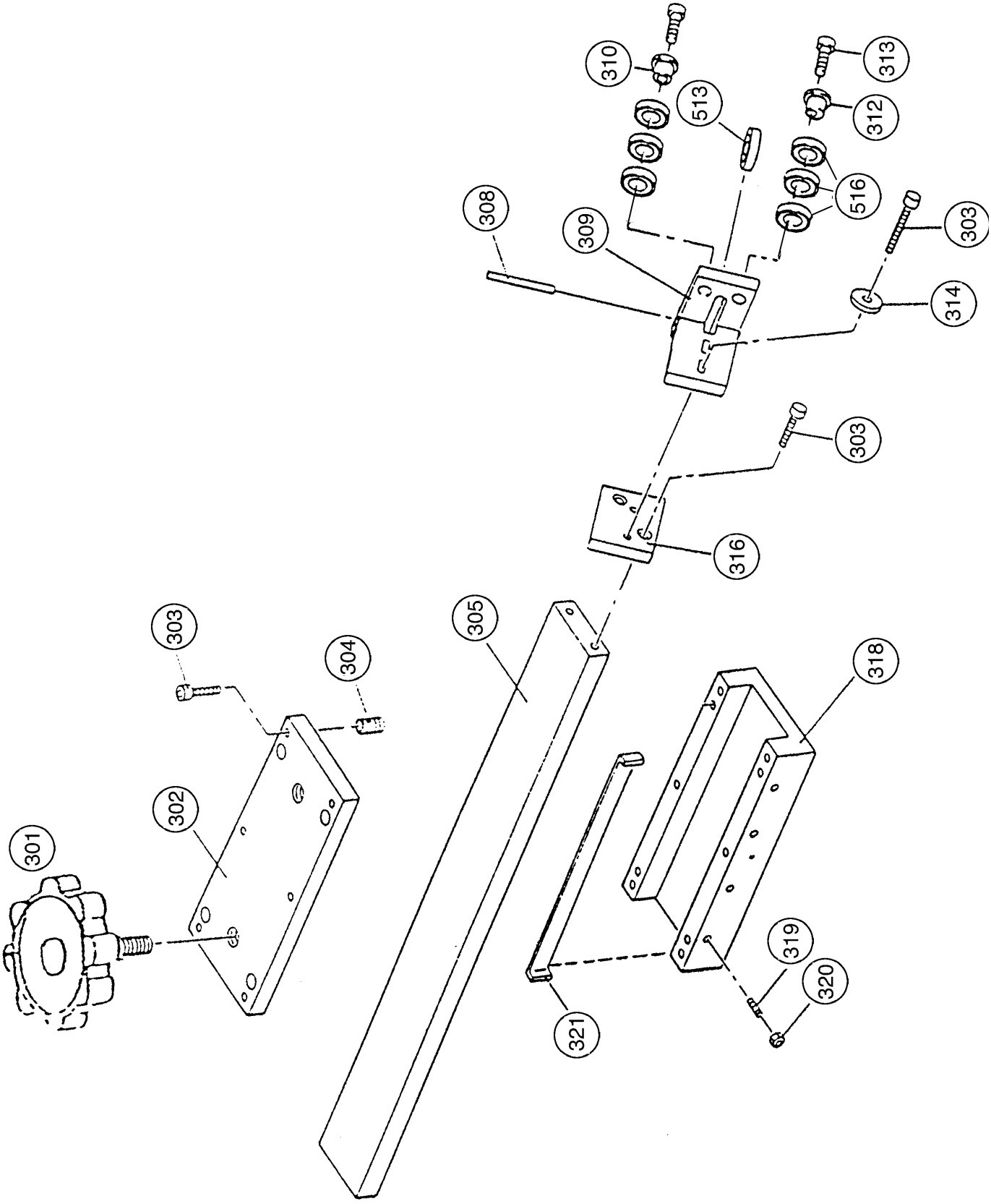
SAW BOW ASSEMBLY



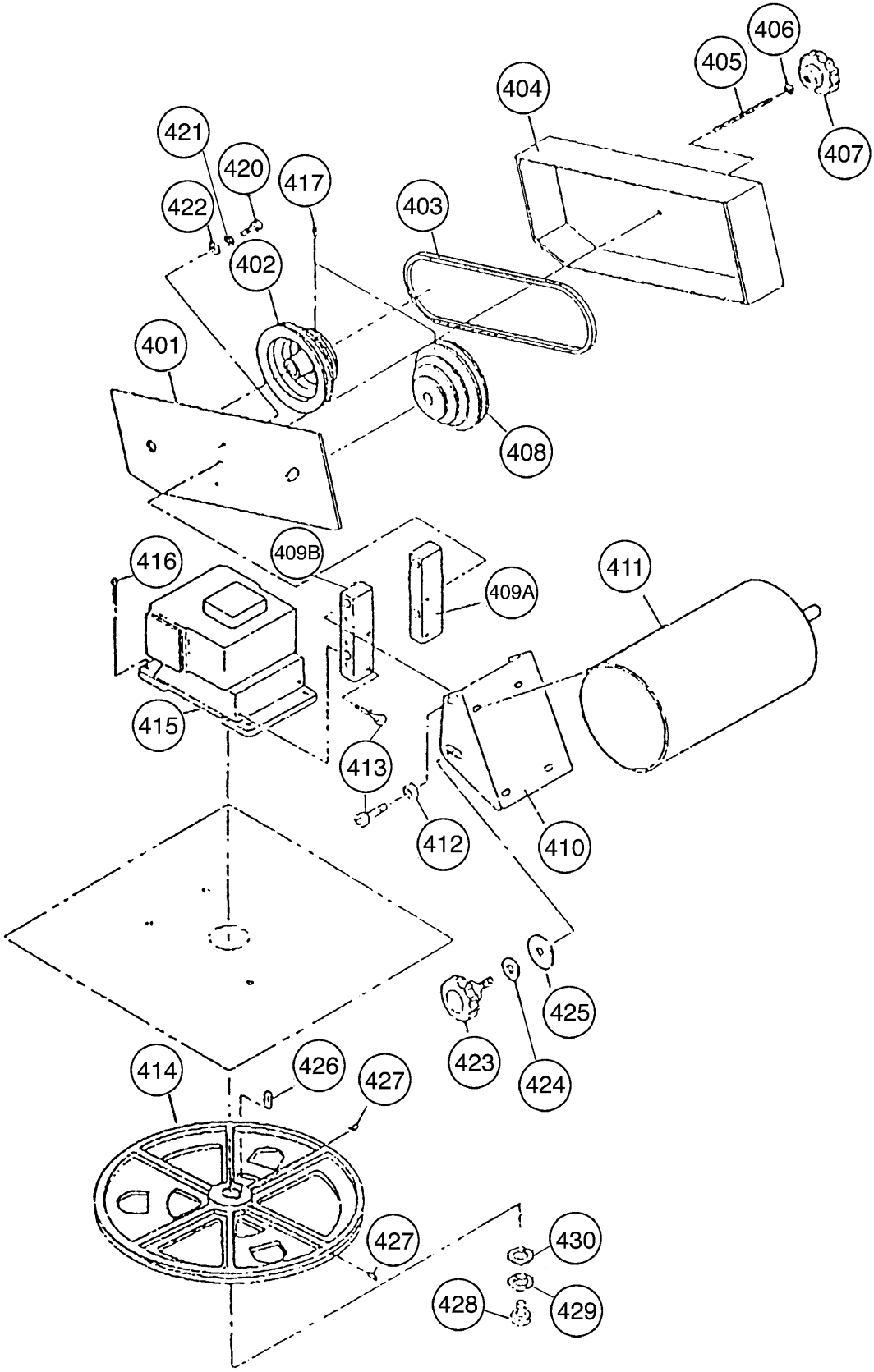
UPPER WHEEL ASSEMBLY



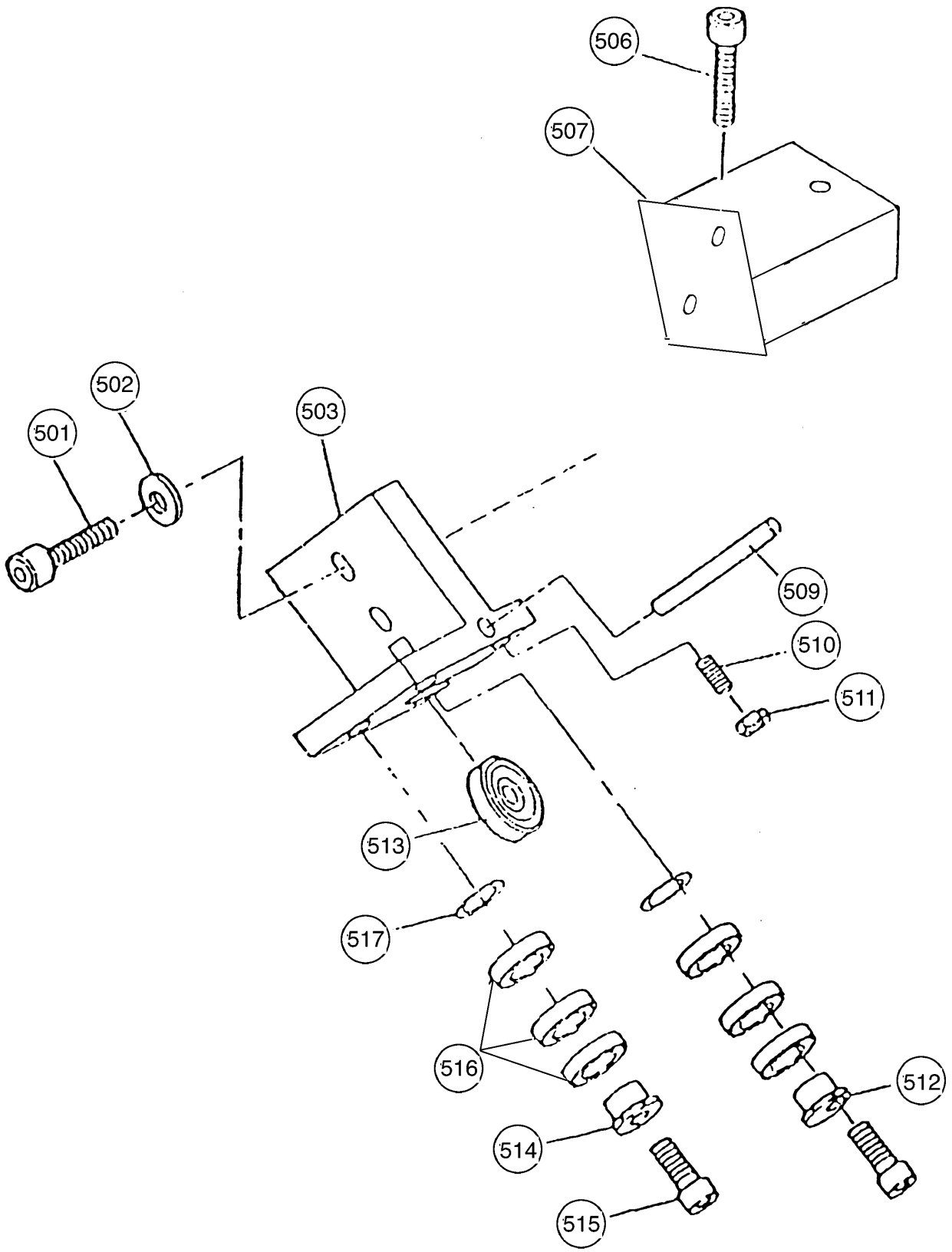
UPPER GUIDE ASSEMBLY



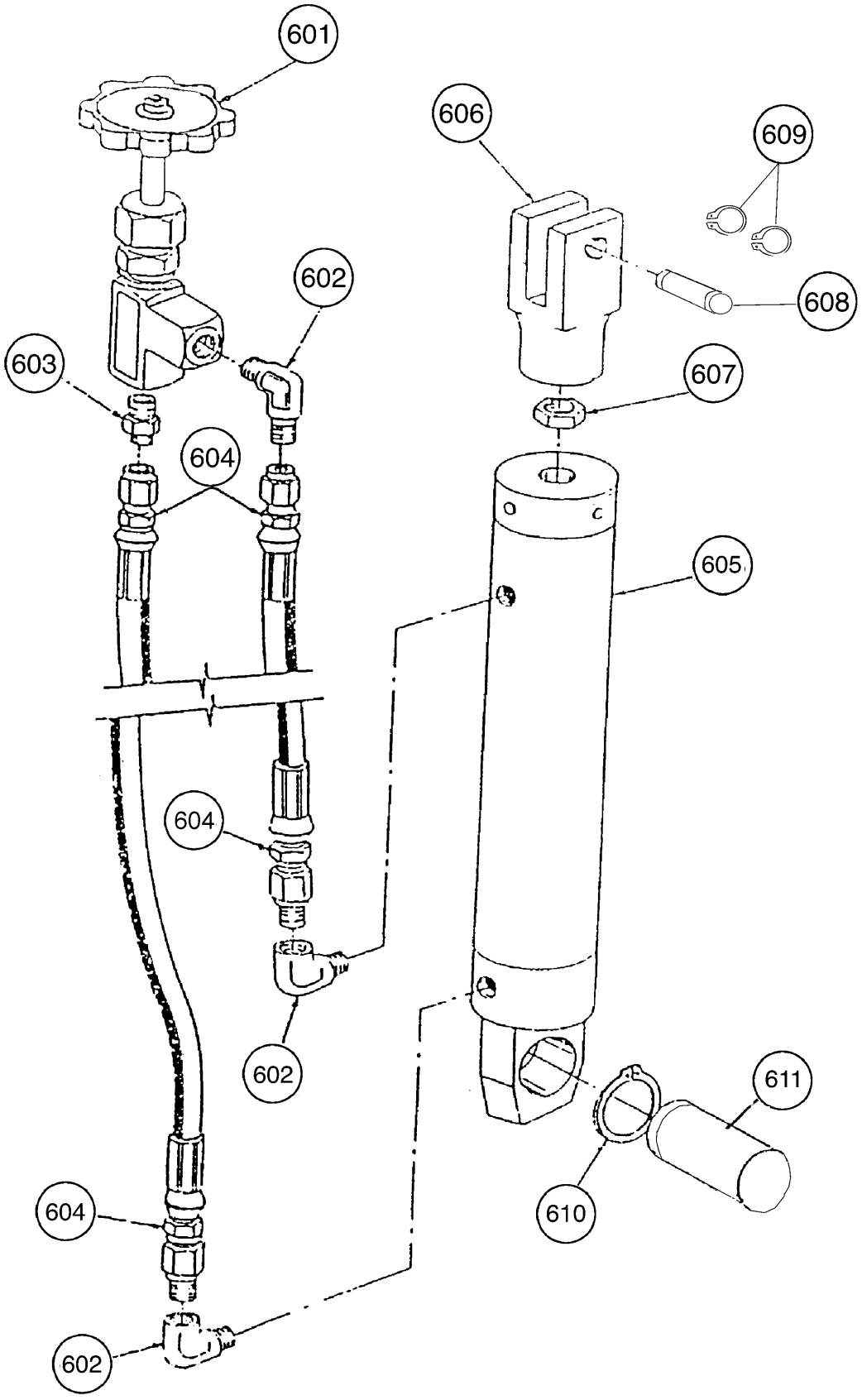
GEAR BOX & MOTOR



LOWER GUIDE ASSEMBLY



HYDRAULICS



NOTES

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number", which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

WARRANTY CARD

NAME_____PHONE NUMBER_____
STREET_____
CITY_____STATE_____ZIP _____
MODEL# G1011 7" x 12" Bandsaw INVOICE#_____

The following information is given on a voluntary basis. This information will be used for marketing purposes to help Grizzly develop better products. Your name will be included in our mailing list only. It will not be sold to other companies. Of course, all information is strictly confidential.

1. How did you find out about us?

__Advertisement __Friend __Other_____
__Catalog __Machinery Show

2. Do you think your machine represents good value? __YES __NO

3. Would you allow us to use your name as a reference for Grizzly customers in your area? __YES __NO
(Note: Your name will be used a maximum of three times.)

4. To which of the following publications do you subscribe? Check all that apply.

__Home Shop Machinist __Rifle Magazine Other _____
__Projects in Metal __Hand Loader Magazine
__Modeltec __Precision Shooter
__Live Steam __RC Modeler
__Shotgun News __Model Airplane News

5. What is your annual household income?

__$20,000-$30,000 __$50,001-$60,000 __$80,000-$90,000
__$30,001-$40,000 __$60,001-$70,000 __+$90,000
__$40,001-$50,000 __$70,001-$80,000

6. To which age group do you belong?

__20-30 __31-40 __41-50 __51-60 __61-70 __71+

7. Which of the following machines or accessories do you own? Check all that apply.

__Engine Lathe __Abrasive Cutoff __Sheet Metal Machine
__Band Saw (Metal) __Arc Welder __Other _____
__Band Saw (Wood) __Oxy/Ac. Outfit
__Milling Machine __Air Compressor
__Bench Grinder __Drill Press

8. How many of the machines you checked in Question 7 are Grizzly machines? _____

9. Which of the following tooling and accessories do you own? Check all that apply.

__Milling Vises __Collet Closer __Digital Readout
__Indexing Head __Taper Attachment __Tool Post Grinder
__Rotary Table __Boring Head __Other _____

10. In the space below, list three tools you would like Grizzly to carry.

_____ _____ _____

11. Of all the mail order metalworking company's you have purchased from, how do you rate Grizzly in terms of overall customer satisfaction?

__The BEST __Above Average __Average __Below Average __The Worst

12. Comments_____
_____
_____
_____
_____

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Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

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Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE